



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18560-1
Job Sheet 178483



Part No: RBT18560-1

Job Qty: ~~6 ea~~

Part Name: Puller



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/31/18

Job Tracking No:

Due Date: 10/29/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG.RBT18560 Rev.4 IPP Rev A 17.11.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		10/29/18	0.00	0.00	Start Up Machining-4		SL
120	Mori Seiki	6 pcs		10/29/18	0.00	12.00	MORI SL2500Y		SL
130	QC	6 pcs		10/29/18	0.00	0.00	QC2 Machining-3		SL
150	QC	6 pcs		10/29/18	0.00	0.00	QC8 Machining-3		B.e 18-11-01
190	Outsource	6 pcs		10/29/18			MEI001-VC (Atlantic) 12		
200	Outsource	6 pcs		10/29/18			GRO002-VC 12		
210	Packaging 7pcs	6 pcs		10/29/18	0.00	0.00	Packaging2		NOV 13 2018
220	QC	6 pcs		10/29/18	0.00	0.00	QC6		38
230	Packaging	6 pcs		10/29/18	0.00	0.00	Packaging3		NOV 14 2018
260	QC21-SA	6 Ea		10/29/18	0.00	0.00			

Part Op 120 - 1-Machine as per folio FB727 FOLIO REV: AA DWG REV: 4 2-Deburr

Descriptions: 150 - INSTALL EXPANDER FIXTURE (RBT18560-1)

190 - 1--Issue P/O to Metcore, P/O Atlantic RC 45-52 ***Heat treat with expander fixture installed***

NOTEREMOVE EXPANDER FIXTURES BEFORE BEAD BLASTING 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech INCLUDING RBT18560-1 EXPANDER FIXTURES NOT INSTALLED

200 - -Issue P/O to Groupe Altech; PO Atlantic -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required ***NOTE***DO NOT SURFACE FINISH RBT560-1 EXPANDER FIXTURES, PLEASE ENSURE TO RETURN EXPANDER FIXTURES TO DART.

210 - Return expander fixtures to the machining dept.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-H13-R2.500	AISI H13 Tool Steel Round Bar	1.5960 ft (266 ea)	90-Start up Operation	5018264-237
				36"

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-H13-R2.500	2	0	0



Dart Aerospace Ltd.
1270 Aberdeen Street
Hemel Hempstead, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S121979



Part: RBT18560-1

Job No: 178483

Serial No/Batch: S121979

Revision: 4

Inspector:

Exp Date:

Instructions:

Date: 10/26/18

Plex 10/19/18 3:32 PM DART.CHAREST-LACOMBE.JULIEN

Specifications could not be found.

Part Specifications

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART
AEROSPACE

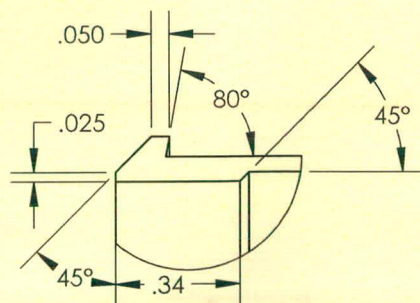
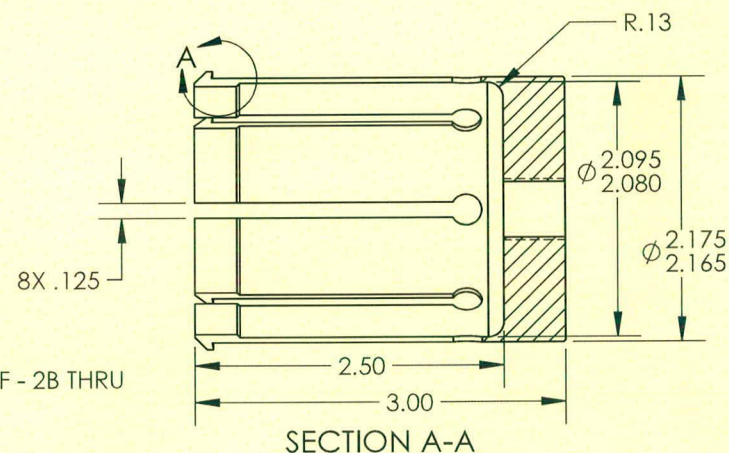
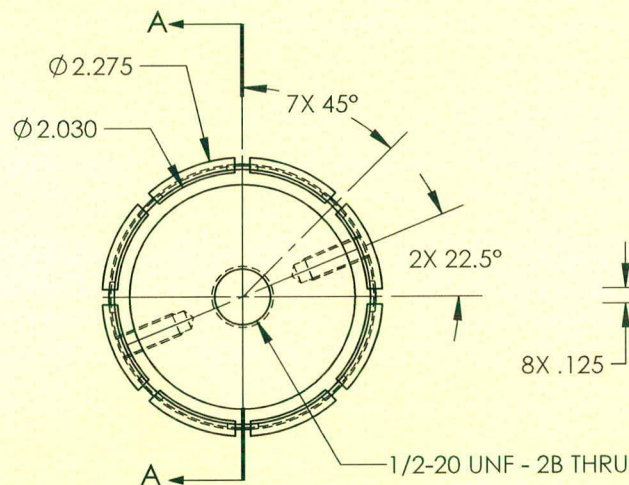
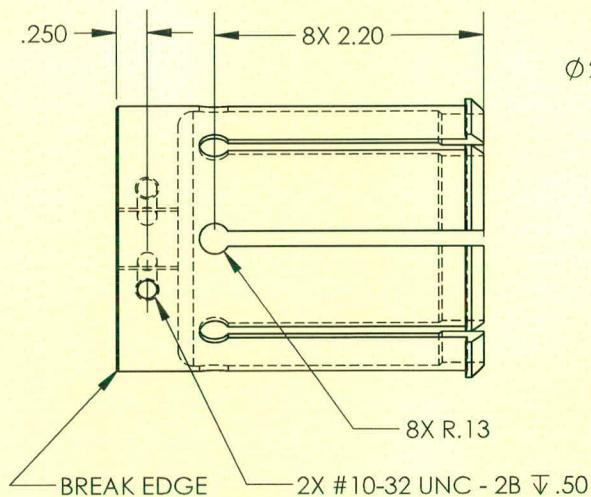
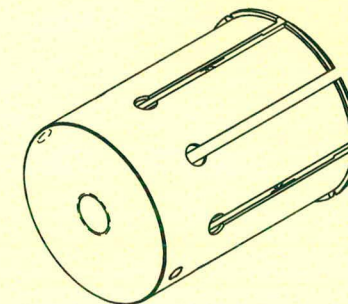
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																															
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REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			



DETAIL A
SCALE 2 : 1

(-1)

PULLER

DART AEROSPACE	
TITLE ENGINE/GEARBOX SEAL PULLER	
DWG NO. RBT18560-1	REV 4
MAT'L H13	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 45-52	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED:	.015 x 45° OR .016R
OPPS APPR:	2. DIMENSIONAL LIMITS APPLY
QA APPR:	AFTER PLATING
APPROVED: WEIL	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 2:3	USED ON MODEL
DATE 5/2/2002	SEE SHT 1
SHEET 2 OF 6	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041570**

Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S R14 Canada
Phone: 866 257 6395

PO No: PO041570
PO Date: 11/2/18
Due Date: 11/9/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	177793	RBEM652V3002101-M-43	Stud 1--Issue P/O to Atlantic ; P/O RC 35-45 2-Bead blast 3- Certificate of Conformity is required -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed -		11/9/18	12 pcs	0 pcs	12 pcs	\$0.01/pcs	\$0.12

12x

NOV 13 2018

8107-6-1-AON

Line Item Note: ** Need by Nov. 9, is this possible? **



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO041570

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	178483	RBT18560-1	1--Issue P/O to Atlantic; P/O RC 45-52 ***Heat treat with expander fixture installed*** ***NOTE***REMOVE EXPANDER FIXTURES BEFORE BEAD BLASTING 2-Bead blast 3- Certificate of Conformity is required -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required ***NOTE***DO NOT SURFACE FINISH RBT560-1 EXPANDER FIXTURES, PLEASE ENSURE TO RETURN EXPANDER FIXTURES TO DART.	Firmed	-	11/9/18	7 pcs	0 pcs	7 pcs	\$0.01/pcs	\$0.07
Grand Total:											\$0.19

DAS
38
9-89

7 sets NOV 13 2018

Order Notes

Procurement Quality Clauses
 A005 right of entry
 A012 chemical and physical test report
 A016 personnel qualification
 A017 raw material identification (as applicable)

A022 Apical Processing
 A024 process certifications
 A026 certification of material conformance

A041 quality management system
 A042 dart notification by supplier
 A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

100
100
100

Atlantic Heat Treating (2001) Ltd

Order No.: 160077

Ship Date: 5/11/2018

Shipping Ticket

Sold To: 1448
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Ship To: 157197
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Page 1 of 1

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
PO041570				

Quantity	Part No. / Part Name / Part Description	Pounds
	12PCS MATERIAL 01 SANDBLAST AND HEAT TREAT TO 35-45RC BLACK OXIDE, C OF C, PRT# RBEM652V3002101-M43, JOB# 177793	

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped: 12

Pounds Shipped: 3.00

Order No.: 160077

Shipped Complete

Quantity Shipped: 12.00

Received By:

Date:

Pounds Shipped: 3.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 11/05/2018

AK
41RC
Bco
11-9-18

Certification

Date: 11/09/2018

Entry Date: 11/05/2018

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: PO041570 ✓

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 01

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
12 ✓	12PCS MATERIAL 01 SANDBLAST AND HEAT TREAT TO 35-45RC BLACK OXIDE, C OF C, PRT# RBEM652V3002101-M-43, JOB# 177793	3

Insp. Type	Scale	Minimum	Maximum	Number	Other
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Customer Requirements:

Harden rockwell

Results:

Harden ROCKWE 35. 45. (41) TESTED AS PER SAMPLING PLAN
HEAT TREATED TO 41 RC AS PER CUSTOMER REQUEST
BLACK OXIDE AS PER CUSTOMER REQUEST

DAS
38
9-89

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY): ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER. IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.


KEAN SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD

Correlation

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